NC machine tool programme setter

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Easier servicing of numerically controlled machine tool is ensured by possibility of correcting the stored programme using the dialogue text display. The latter shows programme lines and dialogue text followed up only after either acceptance or when changes are inserted. The machine tool carriage advance is controlled by feedback signals from a sensor scanning a scale graduations along the machine bed, the scanning head held by the slide. - Programme changes are fed from a keyboard attached to the control unit with the display showing the alternations in the programme for correction checking. The programme uses data which controlled previous machine cycles and the changes are made so that the stored data are unaffected and can be recalled for further control. GBAB- GB2054909 B A process of preparing a numerically controlled machine having control means with a display unit and a data input keyboard, the process comprising conducting a dialogue with the control means through the input keyboard, the dialogue resulting in a working program which includes individual program lines each prepared by the steps of: entering the beginning of the line, and entering responses to dialogue texts specific to parts of the program line, including confirming or altering a proposed value for a variable appearing in a dialogue text, the proposed value being a value retained by the control means from a previous processing operation, the dialogue texts and the entered responses being displayed by the display unit, and the proposed values and the sequences of dialogue texts for respective program lines being determined by the control means so that the said parts of each program line are completely prepared only by the answering of the respective dialogue texts in the predetermined sequence.

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